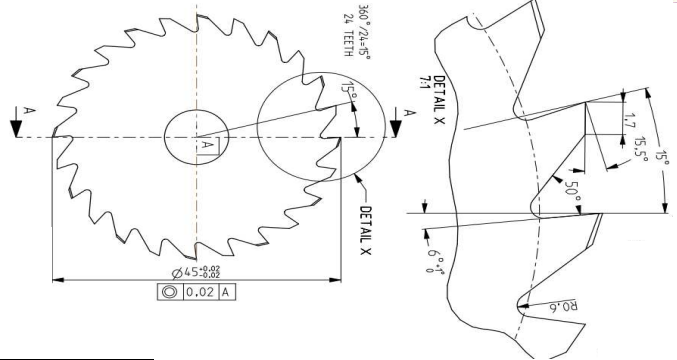
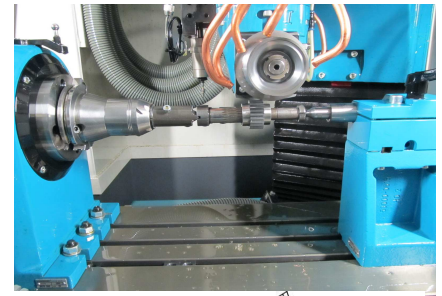
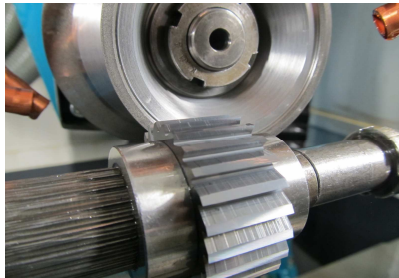


Carbide Saw Blades Ø42 Z24, W 0.37mm

A04-200

The production of a pack of circular sawblades mounted on an arbor with higher material removal on cutting face and OD and polished surfaces can be done as shown below with a pregrinding and polishing process for each surface. Polishing is executed with a grain D20, removing 0.03 per pass.



1. Cycletime for Production

Workpiece:	Pack of total length 22 mm				
	Material CARBIDE				
Operations	Probe	Flute 1	Flute 2	O.D.2	O.D.1
Feed [mm/Min]	2000	80	800	150	800
Power [kW]		3	2	1	2
Cutting speed [m/s]		32	32	32	32
Used wheels		1	2	3	4
Grinding time [s]	9	673	147	343	139
Total cycle time	21 Min 50				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	12V9 Ø50 D64
2	12V9 Ø50 D20
3	11V9 Ø75 D64
4	11V9 Ø75 D20

In this application the cycle time per blade is important. Actually we used a package of 60 saw blades. So the cycle time per blade is 22 seconds.



3 1

2 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : ARIES 5

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP, 21.1.13

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China